

Work Order ID 112988 - 2

112988

Page 1

Tuesday, February 11, 2014 1:04:14 PM

Item ID: PB67-43001-21

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Blade Support And Cover Assembly

Start Date: 2/11/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/28/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: AWL

Date: 14-2-11

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-21	Rev C								

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg PB67-43001

8x CC 14-4-16

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

8x 14-4-17

DAS
24
9-89

120

Identify as per dwg & Stock Location: MEZ 2 0.00

120

Packaging

Memo

0.00

Packaging

8 of 14 14-04-18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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N900040100

Setup

Start

NS1

Revision ID:

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Start Date: 2/11/2014 Start Qty: 12.00

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Cust Item ID:

Required Date: 2/28/2014 Req'd Qty: 12.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21 - Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

PL 14-4-23

MF
14-4-23

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, February 11, 2014 1:04:13 PM

Page 1

Work Order ID: 112988

Parent Item: PB67-43001-21

Start Date: 2/11/2014

Required Date: 2/28/2014

Parent Item Name: Upper Blade Support And Cover Assembly

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev B 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-10 SCREW		Purchased	No			100	Each	584.0000	10	120			

CC 14-4-16

Location

Loc Qty

Loc Code

GA

83

B 128401 → (27x)

120449

83

ST305

1

m126474

1

st507

500

m127993

500

(53x)

(42x)

NAS1149D0316J

Purchased

No

100

Each

1,524.0000

10

120

CC 14-4-16

Washer

Location

Loc Qty

Loc Code

ST293

1000

M127993

1000

ST294

124

123482

124

ST510a

400

M127956

400

(120x)

(78x)

NAS1149D0363J

Purchased

No

100

Each

2,405.0000

12

144

CC 14-4-16

Washer

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

2382

m126319

1190

m127813

1192

(96x)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Tuesday, February 11, 2014 1:04:13 PM

Page 2

Work Order ID: 112988

Parent Item: PB67-43001-21

Start Date: 2/11/2014

Required Date: 2/28/2014

Parent Item Name: Upper Blade Support And Cover Assembly

Start Qty: 12.00

Required Qty: 12.00

PB67-43001-173 Manufactured No
Cover Plate

100 Each 9.0000 1 12 CC 14-4-16

Location

Mezz2 99994

Loc Qty

Loc Code

9 B111817 → (8x)
9

PB67-43001-75 Manufactured No
Upper Blade Support Ass'y

100 Each 6.0000 1 12 CC 14-4-16

Location

Mezz2 106505
111279
111805

Loc Qty

Loc Code

6 B112990 → (8x)
1
1
4

PB67-43001-85 Manufactured No
D-Pad Assembly, Long

100 Each 8.0000 1 12 CC 14-4-16

Location

Mezz2 100025
53241
90818

Loc Qty

Loc Code

8 B111756 → (8x)
4
1
3

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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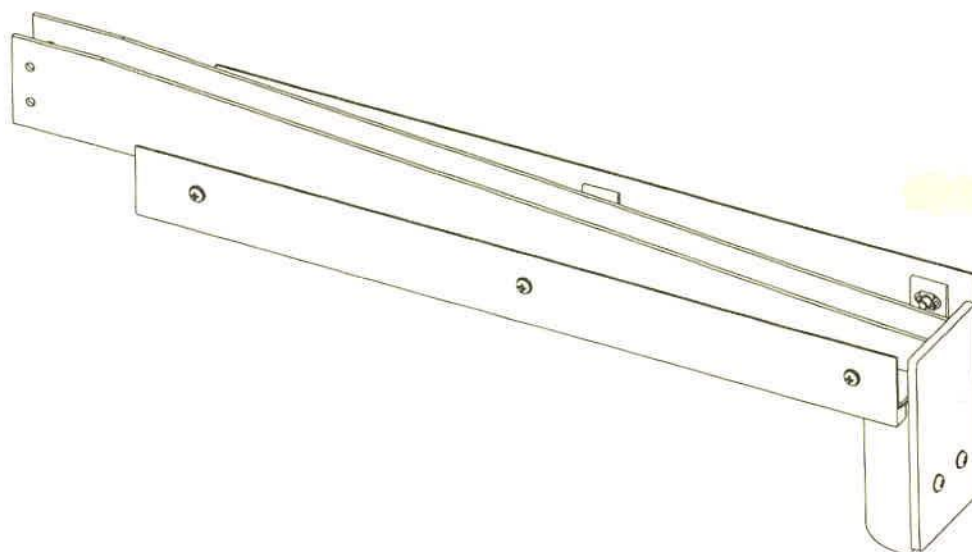
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--	--

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
3	1	B67-43001-75	LOWER BLADE SUPPORT ASSY
4	1	B67-43001-85	LONG D-PAD ASSY
5	1	B67-43001-173	COVER PLATE
7	10	MS27039-1-10	SCREW
8	10	NAS1149D0316J	WASHER
9	12	NAS1149D0363J	WASHER



B67-43001-21 UPPER BLADE SUPPORT AND COVER ASSY

112488
14-2-11

RELEASED
2010-09-16
MB

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 10 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011		MB	09.07.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-21	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	UPPER BLADE SUPPORT AND COVER ASSY	NTS	
DATE	09.07.28		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

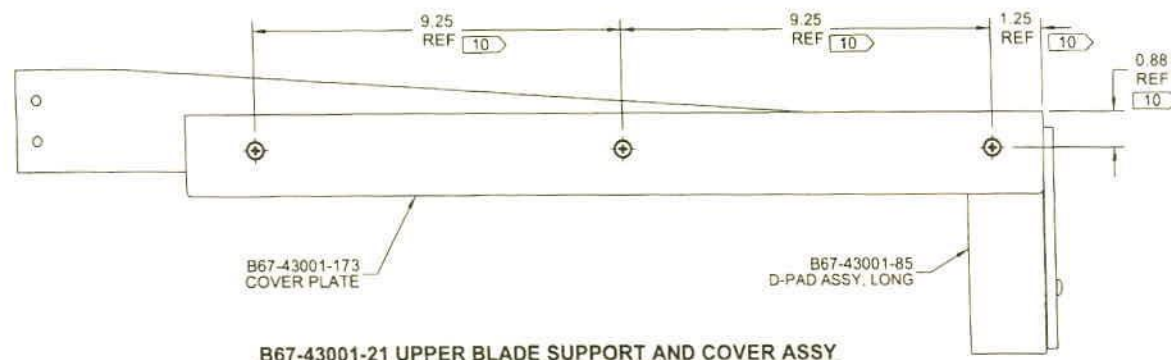
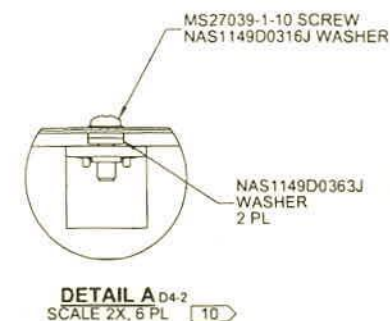
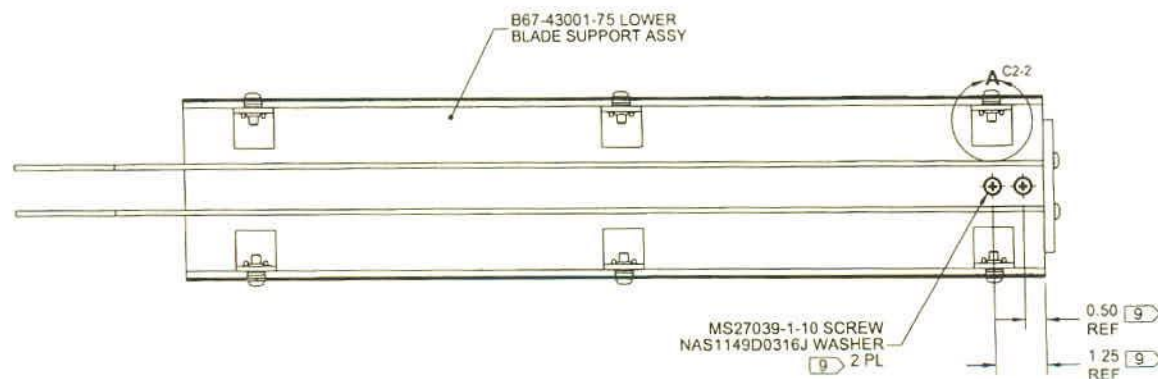
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RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.49 lbs
- 8) WELDING: PER DART QSI 004
- 9) MATCH DRILL $\varnothing$ 0.250 THRU B67-43001-173 WITH HOLE PATTERN OF B67-43001-75
- 10) MATCH DRILL $\varnothing$ 0.250 THRU B67-43001-173 WITH HOLES IN ANGLE BRACKETS ON B67-43001-75

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN	SS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. C
MFG. APPR	SS	B67-43001-21	SHEET 2 OF 2
APPROVED	SS	TITLE	SCALE
DE APPR	N/A	UPPER BLADE SUPPORT AND COVER ASSY	NTS
DATE	09.07.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Folio/Program
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear
☐ Crushing	☐ Countersink	☐ Misaligned/off center
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set
☐ Turning Sequence	☐ Finish	☐ Out of Calibration
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence
		☐ Outside Dimensions
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Set-up
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other